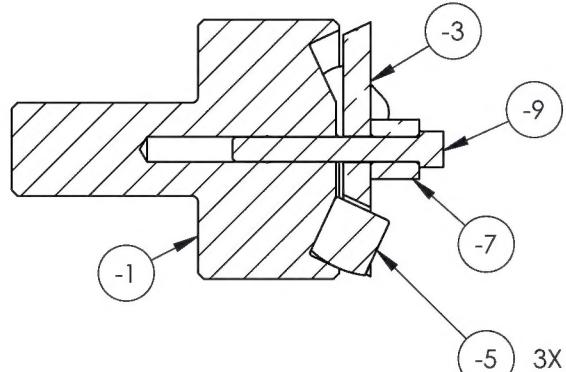
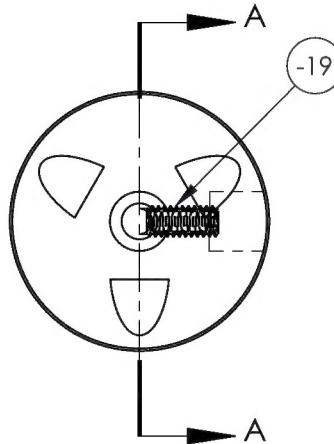
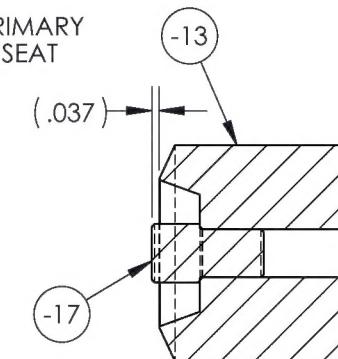
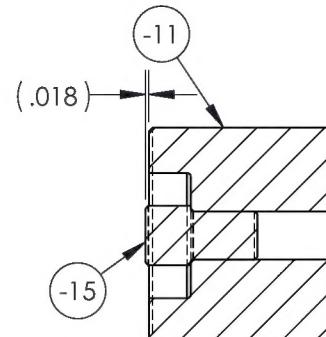


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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1	14-0185	CH'D TITLEBLOCK WAS RED BARN IS DART. -1 CH'D SPECIFICATION WAS $\varnothing 1\text{-}1/2 \times 1\text{-}7/8$ IS $\varnothing 1\text{-}3/8 \times 1\text{-}7/8$. CH'D ENGRAVE NOTE, CH'D DIM WAS #8-32 $\text{V}.675$ IS #8-32 UNC-2B $\text{L}\text{-.187 V}.31$. -9 CH'D MATERIAL WAS 01 IS STEEL, CH'D SPECIFICATION WAS $\varnothing 3/8 \times 1\text{-}1/8$ IS MCMASTER-CARR #98378A909 (MODIFIED). CH'D DIM WAS $\varnothing 241$ IS ($\varnothing .188$), WAS $\varnothing .129 +.000 -.001$ IS ($\varnothing .129$). -11 CH'D ENGRAVE NOTE, -13 CH'D ENGRAVE NOTE.			10/15/2014	DJN	JAG



SECTION A-A



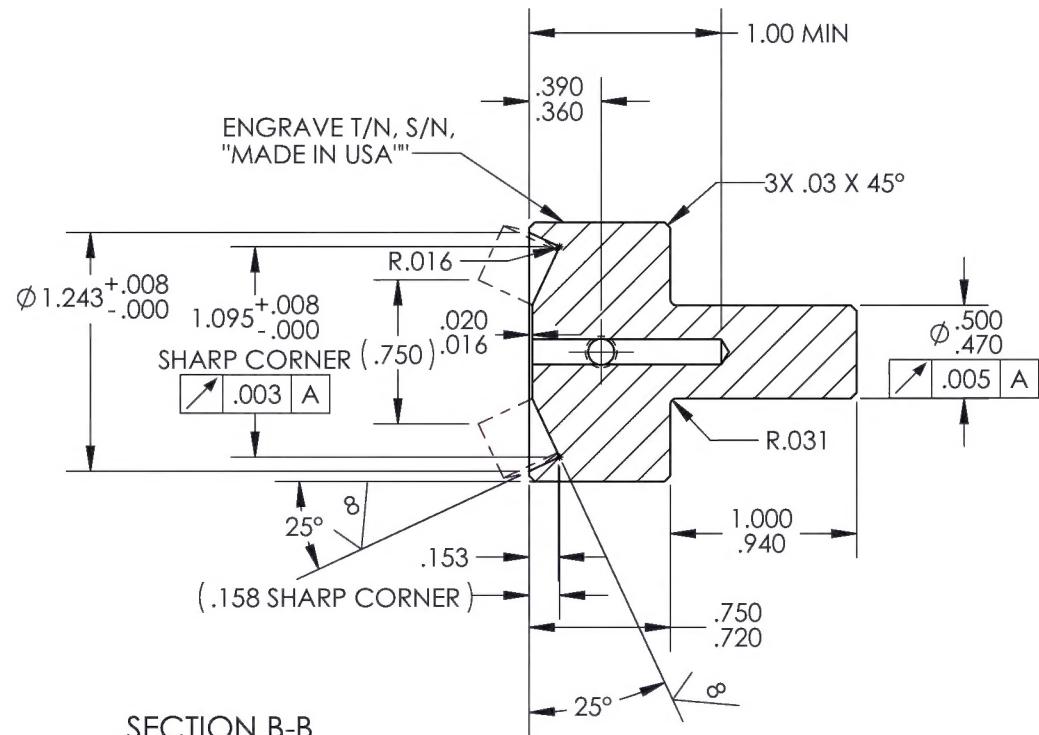
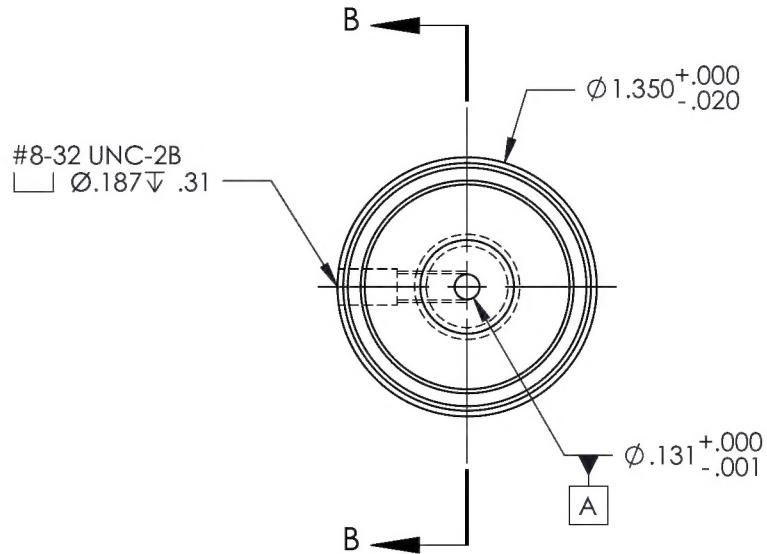
SECONDARY SEAT

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		-1	1	ROLLER FIXTURE	DRILL ROD	$\varnothing 1\text{-}3/8 \times 1\text{-}7/8$		2
		-3	1	RETAINER	BRONZE RND BAR	$\varnothing 1\text{-}1/2 \times 1\text{/4}$		3
		-5	3	ROLLER	STEEL	GAUGE PIN MSC #89031009		4
		-7	1	GUIDE	BRONZE RND BAR	$\varnothing 1/2 \times 3/8$		5
		-9	1	PIN	STEEL	MCMASTER-CARR #98378A909 (MODIFIED)		6
		-11	1	PRIMARY SEAT	4140 Q & T	$\varnothing 1\text{-}1/4 \times 1\text{-}1/8$		7
		-13	1	SECONDARY SEAT	4140 Q & T	$\varnothing 1\text{-}1/4 \times 1\text{-}1/8$		8
		-15	1	LOCATING PIN	1018	$\varnothing 3/8 \times 3/4$		9
		-17	1	LOCATING PIN	1018	$\varnothing 3/8 \times 3/4$		10
B/O	-19	1		SOCKET HEAD SET SCREW	S.S.	8-32 X 3/8 MCMASTER-CARR #97705A406		1

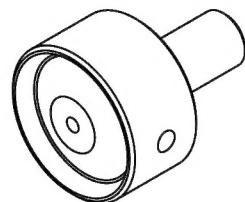
DART AEROSPACE		
TITLE TRI-ROLLER SWAGING TOOL		
DWG NO. RBST2854 REV 1		
MAT'L DRAWN BY: GILBERT		
UNLESS OTHERWISE SPECIFIED APPROVED <i>D Weil</i>		
DIMENSIONS ARE IN INCHES		
.XXX ± .005 FRACTIONS ± 1/8		
.XX ± .01 ANGLES ± 5°		
X ± .1 FINISH		
SPEC		
1. BREAK ALL SHARP EDGES .015 x 45° USED ON MODEL		
OR .015R		
2. DIMENSIONAL LIMITS APPLY AFTER PLATING 212-310-701-103		
SCALE 1:1	DATE 3/29/2011	SHEET 1 OF 10

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REV			ECR			DESCRIPTION			DATE		INITIAL		APPROVED	
1	14-0185		-1	CH'D ENGRAVE NOTE, CHG'D DIM WAS #8-32 ∇ .675 IS #8-32 UNC -2B \sqcup Ø.187 ∇ .31.					10/15/2014		DJN	JAG		



SECTION B-B



(1)

ROLLER FIXTURE

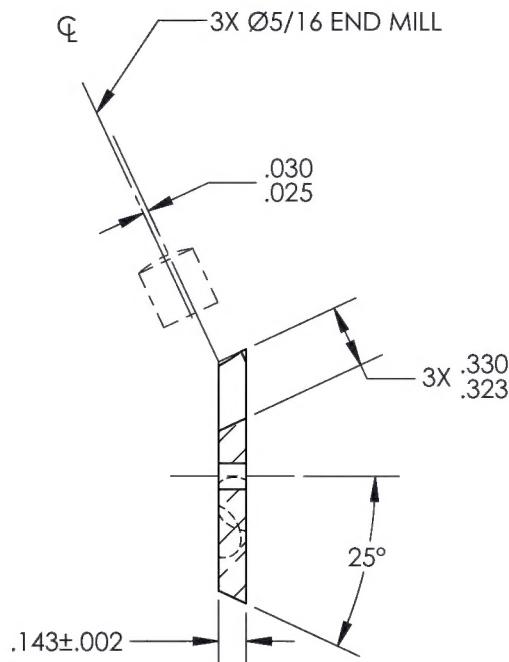
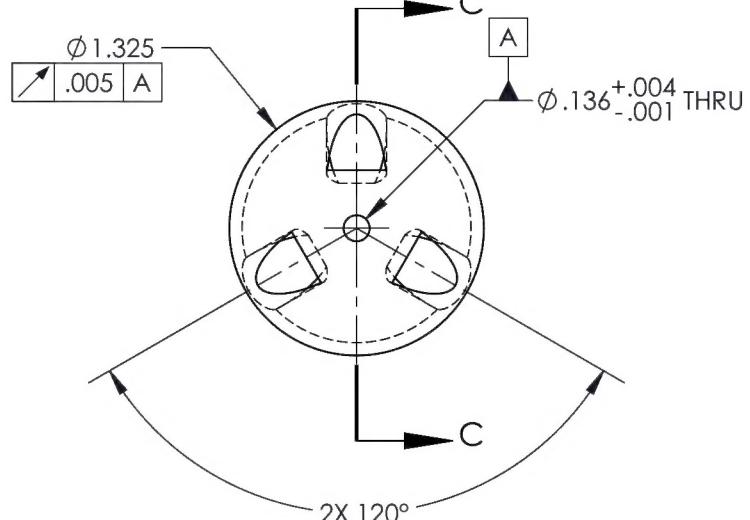
NOTES:

1. ROLLER RACE SURFACES MUST HAVE SMOOTH APPEARANCE, FREE FROM MACHINING MARKS AND GROOVES.
2. DO FIRST ARTICLE INSPECTION BEFORE HEAT TREATING.

DART AEROSPACE	
TITLE	
TRI-ROLLER SWAGING TOOL	
DWG NO.	REV
RBST2854-1	1
MAT'L DRILL ROD	DRAWN BY: GILBERT
APPROVED <i>D. Weil</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL 212-310-701-103	
SCALE 1:1	DATE 5/20/2013
SHEET 2 OF 10	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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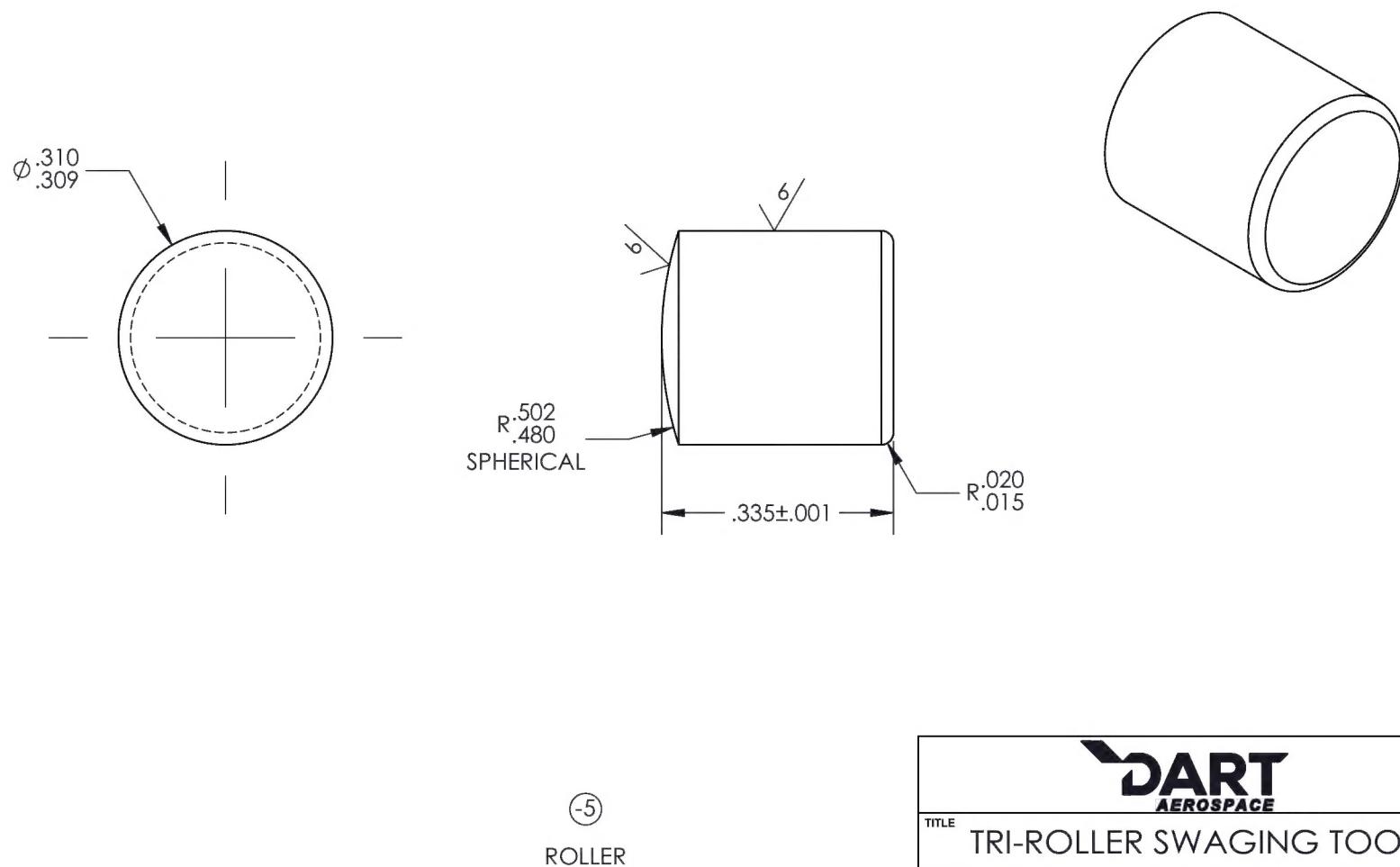
SECTION C-C

(-3)
RETAINER

DART AEROSPACE	
TITLE	
TR-ROLLER SWAGING TOOL	
DWG NO.	REV
RBST2854-3	
MAT'L	DRAWN BY:
BRONZE RND BAR	GILBERT
APPROVED	
<i>D Weil</i>	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
.X ± .1	
SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL	
212-310-701-103	
SCALE	DATE
1:1	5/20/2013
SHEET 3 OF 10	

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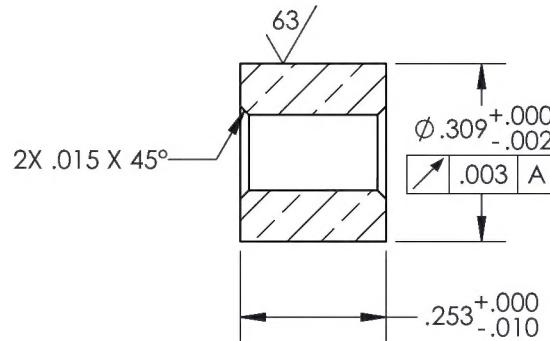
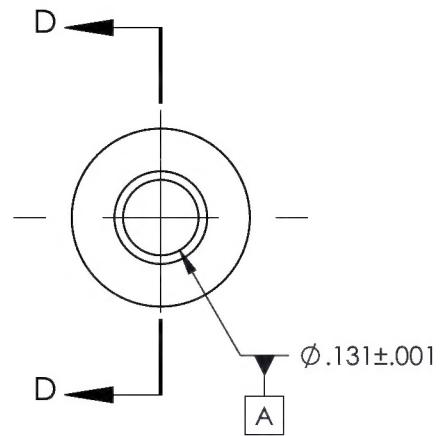
REV		ECR		REVISIONS		
				DESCRIPTION		DATE
				INITIAL	APPROVED	



DART AEROSPACE	
TITLE	
TRI-ROLLER SWAGING TOOL	
DWG NO.	REV
RBST2854-5	
MAT'L	DRAWN BY:
STEEL	GILBERT
APPROVED	
<i>D. Weil</i>	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8	
.XX ± .01 ANGLES ± 5°	
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45°	
OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER	
PLATING	
USED ON MODEL	
212-310-701-103	
SCALE	DATE
4:1	5/20/2013
SHEET 4 OF 10	

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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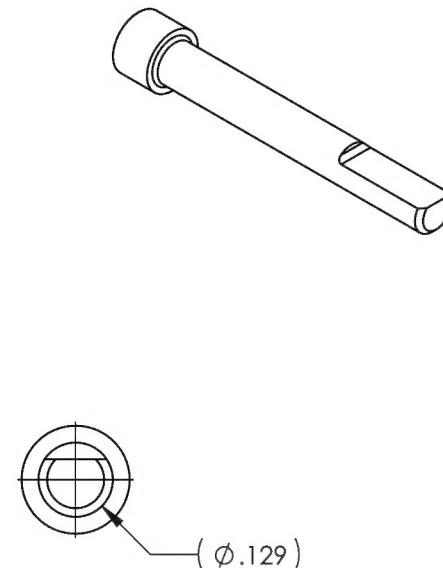
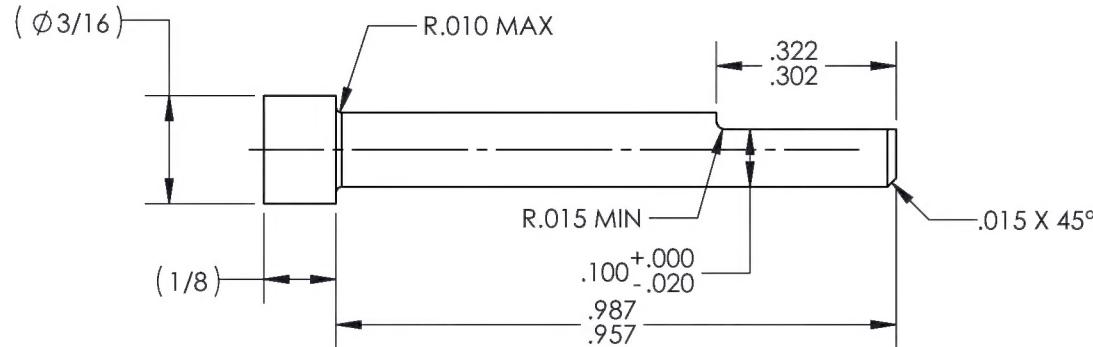
SECTION D-D

(-7)
GUIDE

DART AEROSPACE	
TITLE	
TRI-ROLLER SWAGING TOOL	
DWG NO.	REV
RBST2854-7	1
MAT'L BRONZE RND BAR	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED	APPROVED <i>D Weil</i>
DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/8
.XX ± .01	ANGLES ± 5°
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45°	
OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER	
PLATING	
USED ON MODEL	
212-310-701-103	
SCALE 3:1	DATE 5/20/2013
SHEET 5 OF 10	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1	14-0185	-9 CH'D DIM WAS Ø.241 IS (Ø.188). WAS Ø.129 +.000 -.001 IS (Ø.129).	10/15/2014	DJN	JAG



(-9)

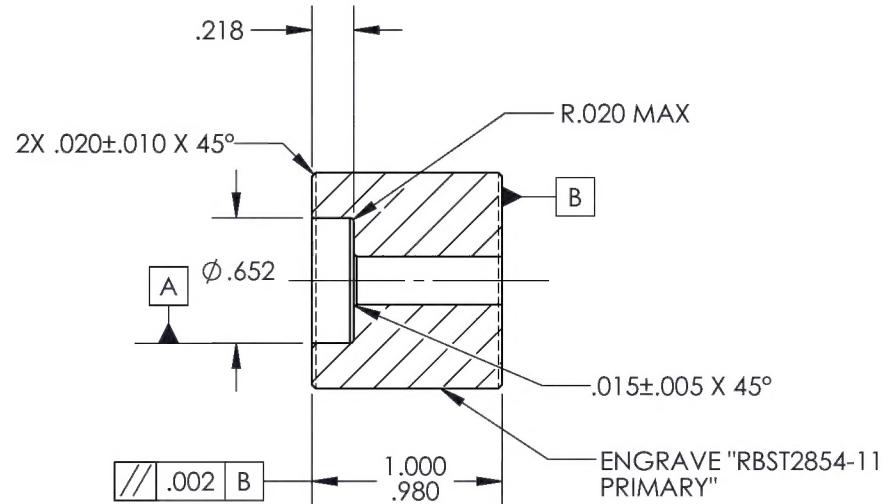
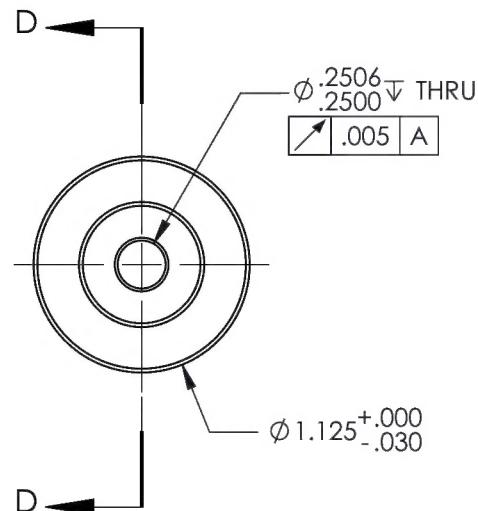
PIN

DART AEROSPACE	
TITLE	
TRI-ROLLER SWAGING TOOL	
DWG NO.	RBST2854-9
MAT'L	STEEL
DRAWN BY:	GILBERT
APPROVED	D Weil
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/8
.XX ± .01	ANGLES ± 5°
X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45°	
OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER	
PLATING	
USED ON MODEL	
212-310-701-103	
SCALE	3:1
DATE	5/20/2013
SHEET 6 OF 10	

REV
1

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REVISONS			DESCRIPTION			DATE	INITIAL	APPROVED
REV	ECR							
1	14.0185		-11 CH'D ENGRAVE NOTE.			10/15/2014	DJN	JAG



SECTION D-D

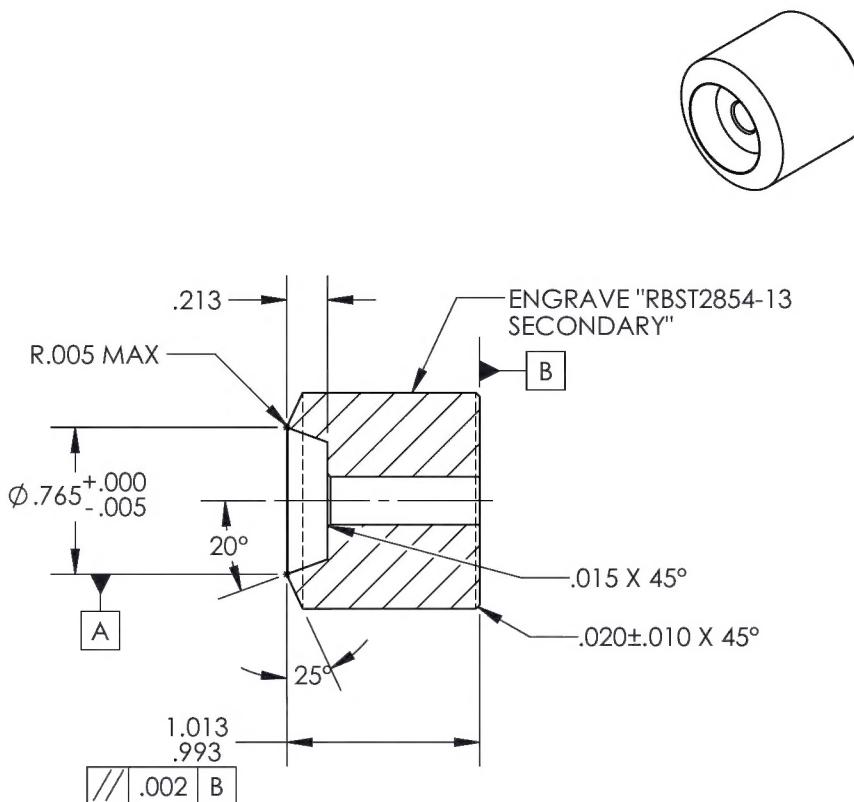
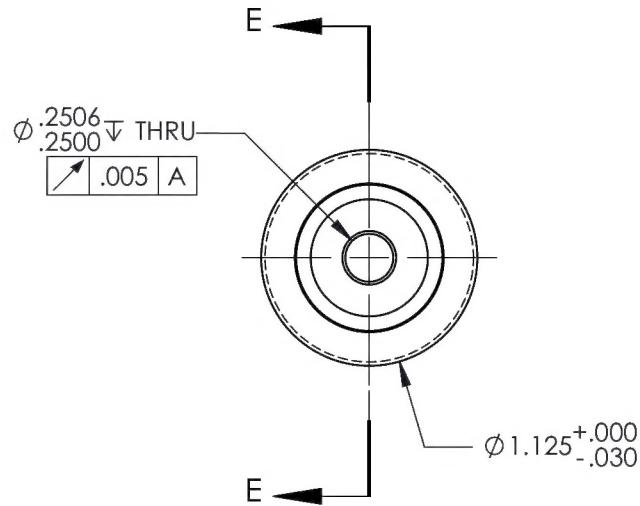
(11)
PRIMARY SEAT

DART AEROSPACE	
TITLE: TRI-ROLLER SWAGGING TOOL	
DWG NO.	REV 1
RBST2854-11	
MAT'L 4140 Q & T	DRAWN BY: GILBERT
APPROVED <i>D Weil</i>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/8
.XX ± .01	ANGLES ± 5°
X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL 212-310-701-103	
SCALE 1:1	DATE 5/20/2013
SHEET 7 OF 10	

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REVISONS		
REV	ECR	DESCRIPTION
1	14-0185	-13 CH'D ENGRAVE NOTE.

DATE	INITIAL	APPROVED
10/15/2014	DJN	JAG



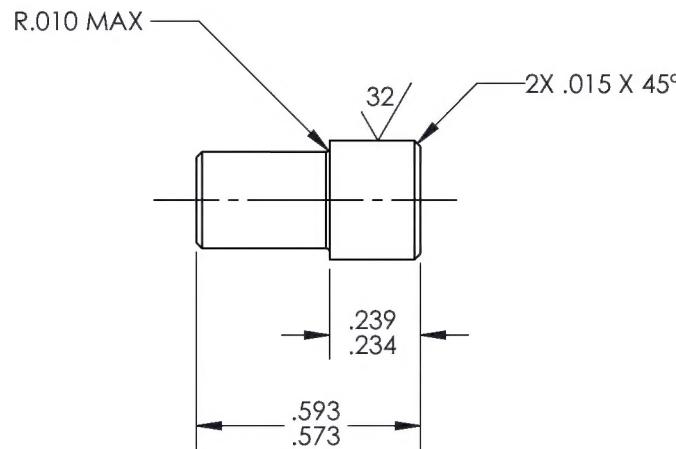
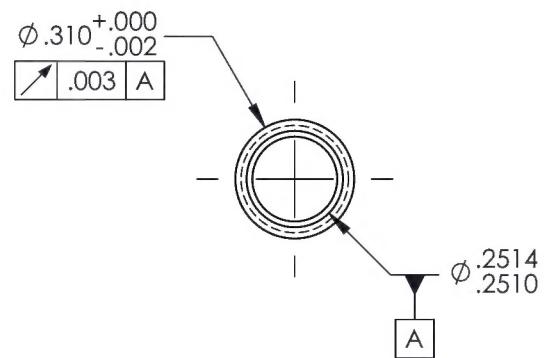
SECTION E-E

(-13)
SECONDARY SEAT

DART AEROSPACE	
TITLE TRI-ROLLER SWAGING TOOL	
DWG NO. MAT'L 4140 Q & T	REV 1 DRAWN BY: GILBERT APPROVED D Weil
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	
1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
HEAT TREAT FINISH BLACK OXIDE SPEC USED ON MODEL 212-310-701-103	
SCALE 1:1	DATE 5/20/2013 SHEET 8 OF 10

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REV	ECR	REVISIONS	DESCRIPTION	DATE	INITIAL	APPROVED
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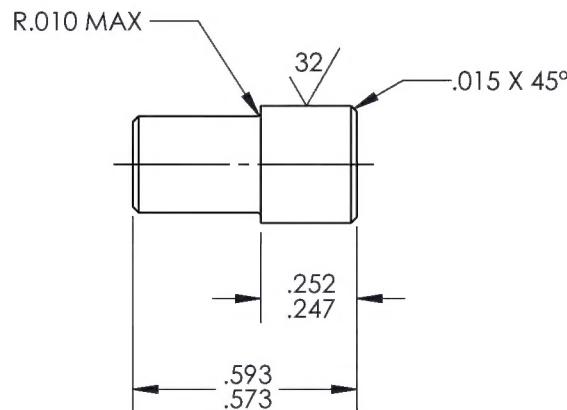
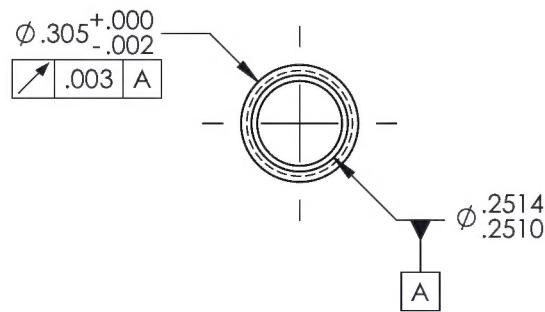
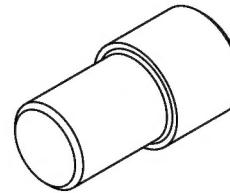
(-15)

LOCATING PIN

DART AEROSPACE	
TITLE: TRI-ROLLER SWAGING TOOL	
DWG NO.	REV
RBST2854-15	1
MAT'L 1018	DRAWN BY: GILBERT
APPROVED D Weil	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/8
.XX ± .01	ANGLES ± 5°
X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45°	
OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER	
PLATING	
USED ON MODEL	
212-310-701-103	
SCALE 2:1	DATE 5/21/2013
SHEET 9 OF 10	

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REV		ECR		DESCRIPTION			DATE	INITIAL	APPROVED
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-17
LOCATING PIN

DART AEROSPACE	
TITLE TRI-ROLLER SWAGING TOOL	
DWG NO.	REV 1
RBST2854-17	
MAT'L 1018	DRAWN BY: GILBERT
APPROVED <i>D Weil</i>	
UNLESS OTHERWISE SPECIFIED	
DIMENSIONS ARE IN INCHES	
.XXX ± .005	FRACTIONS ± 1/8
.XX ± .01	ANGLES ± 5°
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45°	
OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER	
PLATING	
USED ON MODEL	
212-310-701-103	
SCALE 2:1	DATE 5/21/2013
SHEET 10 OF 10	